

Work Order ID 99492***99492***

Page 1

April 10, 2013 11:26:30 AM

Item ID: D3255

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Gasket

Stop

NS2

Start Date: 4/10/13

Start Qty: 54.00

54

Cust Item ID:

Required Date: 4/15/13

Req'd Qty: 54.00

54

Customer:

Reference:

Approvals:	Process Plan:	<u>CX</u>	Date: 13/04/10	Tooling:	Date:	Run	Start	*NR1*
	QC:		Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence # Work Center ID	Operation Description	Set Up/ Run Hours	OP	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Stamp
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Draw Nbr	Revision Nbr								
D3255	Rev B								

100	0.00								
100	PURCHASING								

Purchasing	Memo	0.00							
Purchasing	Issue P/O:	<u>19543</u>							

Possible Supplier: McMaster Carr P/N: 8612K61
 Material: Silicone coated fiberglass cloth per AMS 3320F
 36' x 36' x 1/16"
 Certificate of conformity required

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110	Memo	0.00							
Packaging	Ensure Material Release Note is attached								

CX 13/04/10 54

54x 13-4-11 SP

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Accept

N900040100

Setup Start

NS1

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NS2

Item Name: Gasket

Start Date: 4/10/13

Start Qty: 54.00

54

Cust Item ID:

Required Date: 4/15/13

Req'd Qty: 54.00

54

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

21
B 4/11

SY

130

130

Packaging

Packaging

Identify as per dwg & Stock Location: MAT052 0.00

0.00

54

JW34 n

140

140

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

13/4/15

QB-04-12

Picklist Print

April 10, 2013 11:26:30 AM

Page 1

Work Order ID: 99492

Parent Item: D3255

Parent Item Name: Gasket

Start Date: 4/10/13

Required Date: 4/15/13

Start Qty: 54.00

Required Qty: 54.00

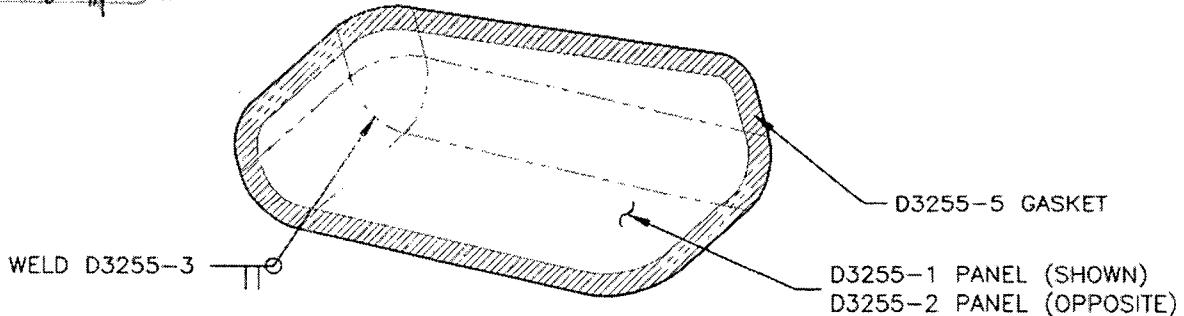
Comments: IPP A04.04.06New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
SIL/F36X36X1/16 Gasket		Purchased		No		100	sf	0.0000	1	54	54	SP 13~4~11	

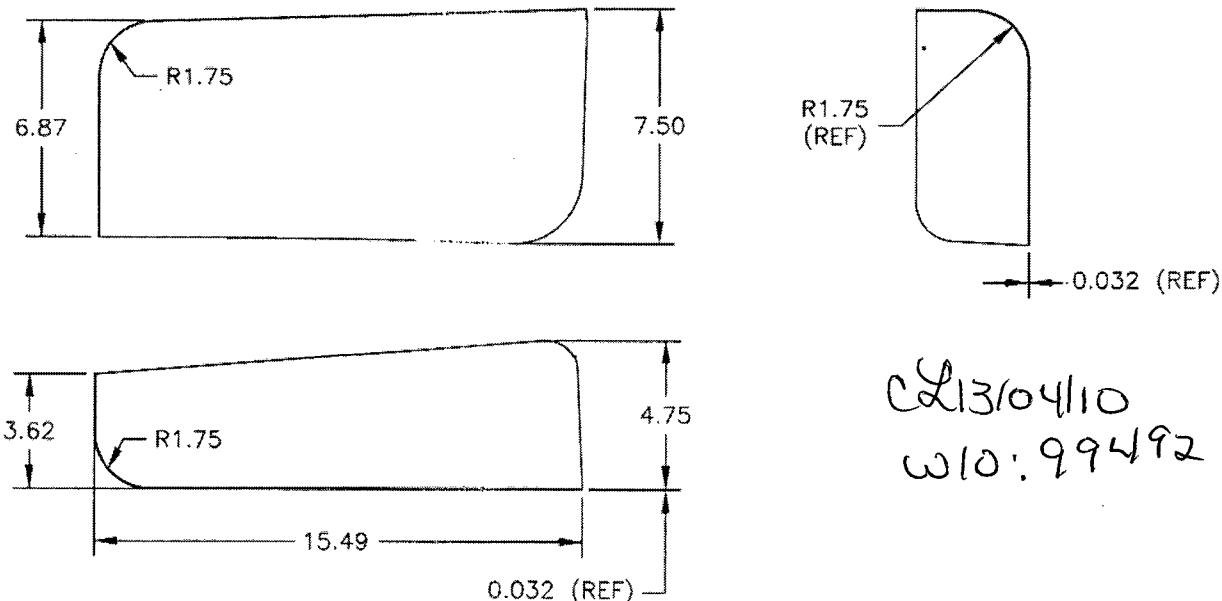


DESIGN PF	DRAWN BY PF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED IP	APPROVED <i>[Signature]</i>	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05.01.18 *[Signature]*



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

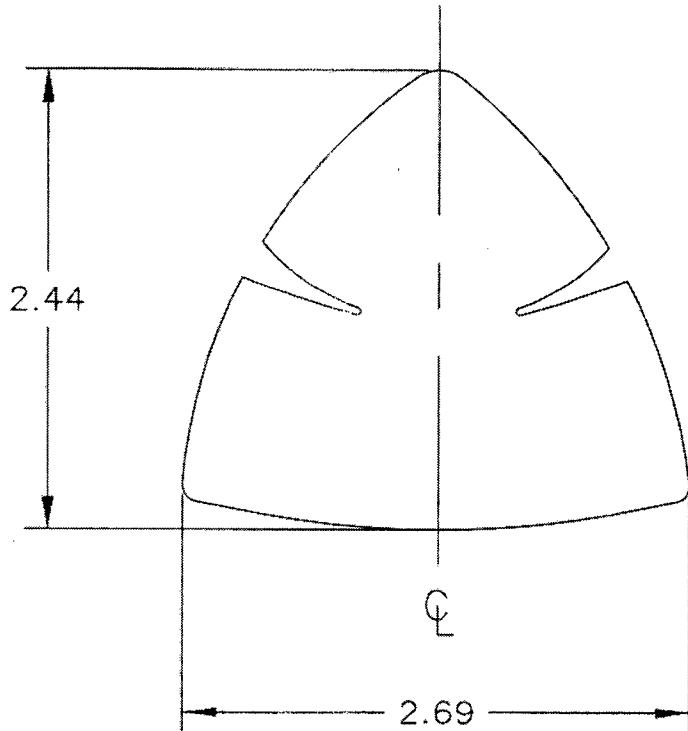
D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER



DESIGN <i>JF</i>	DRAWN BY <i>JF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>P</i>	APPROVED <i>JF</i>	DRAWING NO. D3255
DATE 04.12.06	TITLE	REV. B SHEET 2 OF 4 SCALE 1:1

RELEASED
05.01.18 *JF*



D3255-3 CAP
FORM TO FIT D3155-1/-2

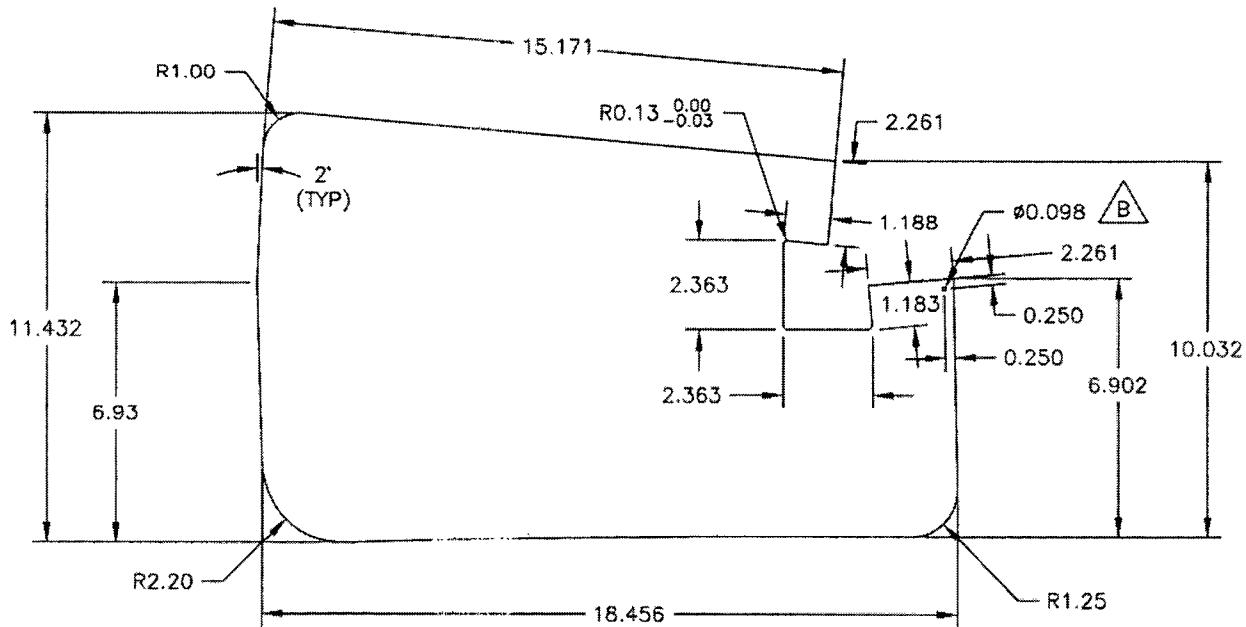
D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES .005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"



DESIGN <i>RF</i>	DRAWN BY <i>TF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>IP</i>	APPROVED <i>MM</i>	DRAWING NO. D3255	REV. B	SHEET 3 OF 4
DATE 04.12.06	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:5	

RELEASED
05-01-18



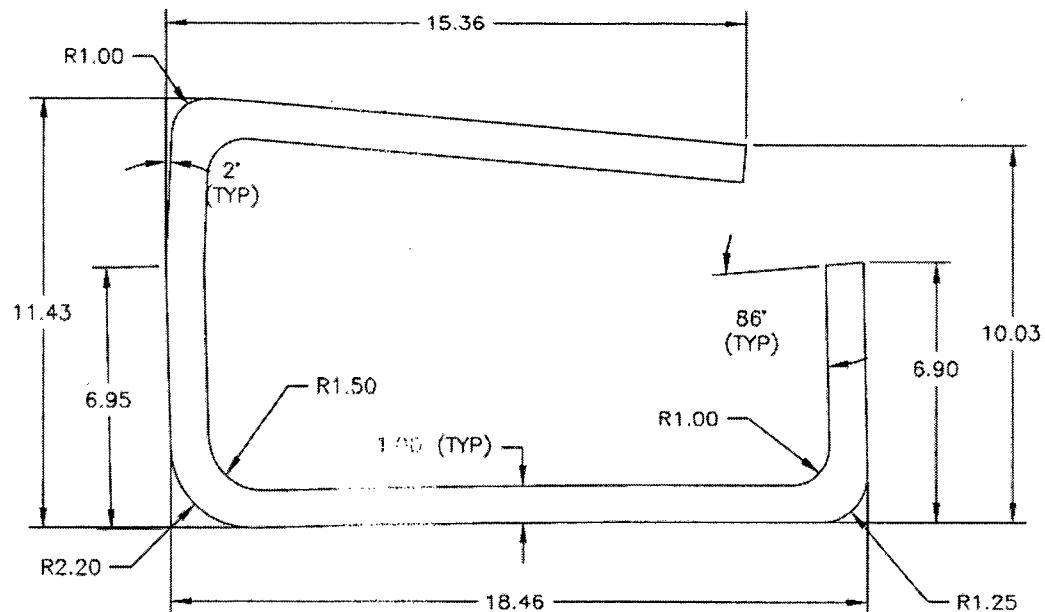
D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DART

DESIGN <i>IP</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>IP</i>	APPROVED <i>PF</i>	DRAWING NO. D3255
DATE 04.12.06	TITLE	REV. B SHEET 4 OF 4 SCALE 1:5 ACCESS PANEL ASSEMBLY

RELEASED
05.01.18 *PF*D3255-5 GASKETD3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

200 Aurora Industrial Pkwy
 Aurora OH 44202-8087
 330-995-5500
 cle.sales@mcmaster.com

Dart Aerospace Ltd
 1270 Aberdeen St
 Hawkesbury ON K6A 1K7
 Canada

Purchase Order
PO19543

Page 1 of

Order Placed By
Chantal Lavoie

04/10/201

McMaster-Carr Number
1654605-03

Line	Description	Ordered	Shipped			
4	8612K61 Fiberglass Fabric-Reinforced Silicone Rubber, Plain Back, 1/16" Thick, 24" X 36"	9 Each	9	8 - 64 - 37	86 - 73	K61 9 EA 24 lbs

Shipped separately from our Chicago warehouse on 04/10

2	92311A639 18-8 Stainless Steel Cup Point Set Screw, 3/8"-24 Thread, 1" Long	10 Packs	3
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Charges for this shipment

Merchandise Amount	\$643.95
Total:	\$643.95

BB3411

Dart Aerospace Ltd

EXI
INV



Lg
 38x12x12

FW1F
 04/10
 14:32
 522
 Cycle 1

1140711045526